

5/11

DART AEROSPACE LTD	Work Order:	22562
Description: Slider Body	Part Number:	D3400-5
Dwg: D3372 Rev. B page 8; D3400 Rev. A page 3, 6	Qty:	10
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	HA	05.02.28	10
2	MV	Cut blank: 1.500" x 1.250" x 4.435" long Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8) (M6061T6B1.500x01.250) Identify for D3400-5 Batch: <u>M7703</u>	SD	05.03.01	12
3	MV	Machine D3400-5 as per Folio FA515 and Dwg D3400 Identify as D3400-5	SA	05.09.25	12
4	QC2	Inspect parts as they come off the CNC machine	SD	05.09.25	12
5	QC8	Second check	gml	05/09/27	12
6	MV	Deburr	SD	05.09.25	12
7	FP	Chemical Conversion Coat as per QSI 005 4.1	SAD	05/11/19	12
8	QC3	Inspect Chemical Conversion Coat	SB	05/11/21	12
9	MV	Fabricate D3372-9 using AN6-36A bolt as per Dwg D3372. Cut to length, then mill slot when bolt and D3400-5 are assembled as per Dwg D3400. Pick: Qty Part Number Description Batch 1 AN6-36A Bolt <u>M17405</u>	FE	05.11.21	12
10	QC5	Inspect work to Step 9	En	06/01/18	12
11	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3 Mask all holes and pins	M	06.02.01	12
12	QC3	Inspect Powder Coat	CL	06/02/06	12
13	ST	Identify and Stock LOC 3 72	CL	06/02/06	12
14	AC	Cost / part	Sur	06.02.01	12
15	DC	Close W/O Inspect Level 21	DP	06/02/07	12

Rev	Date	Change	Revised By	Approved
A	05.02.24	New issue	KJ/JLM	

RELEASED
2025-02-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: DD Date: 06/02/07

NOTE: Date & initial all entries

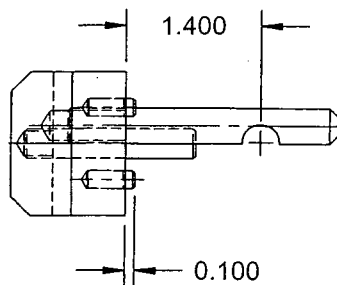
QA: N/C Closed: _____ Date: _____



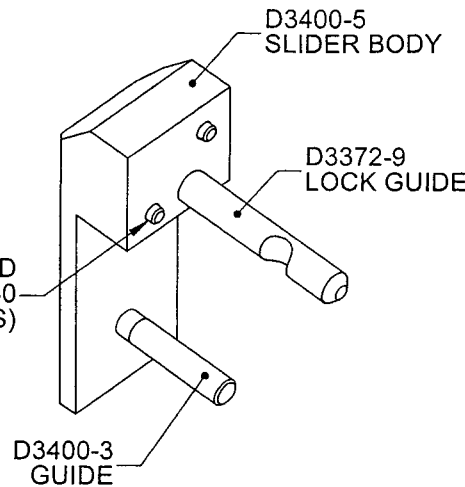
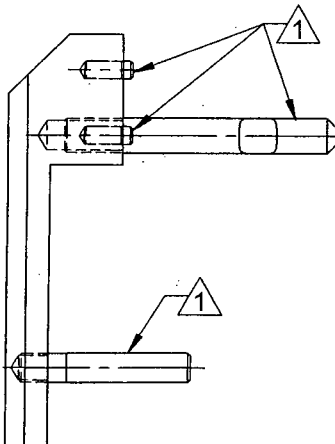
DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED [Signature]	DRAWING NO. D3400	REV. A SHEET 3 OF 6
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2

RELEASED

05/04/23



STD. GROUND
DOWEL PIN $\varnothing 3/16 \times 0.50$
(2 PLACES)



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WORK ORDER
NO. 2282

D3400-055 SLIDER ASS'Y

NOTES:

- 1) COVER DOWEL PIN (2 PLACES), D3400-3 AND D3372-9 PRIOR PAINTING
- 2) FINISH: POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

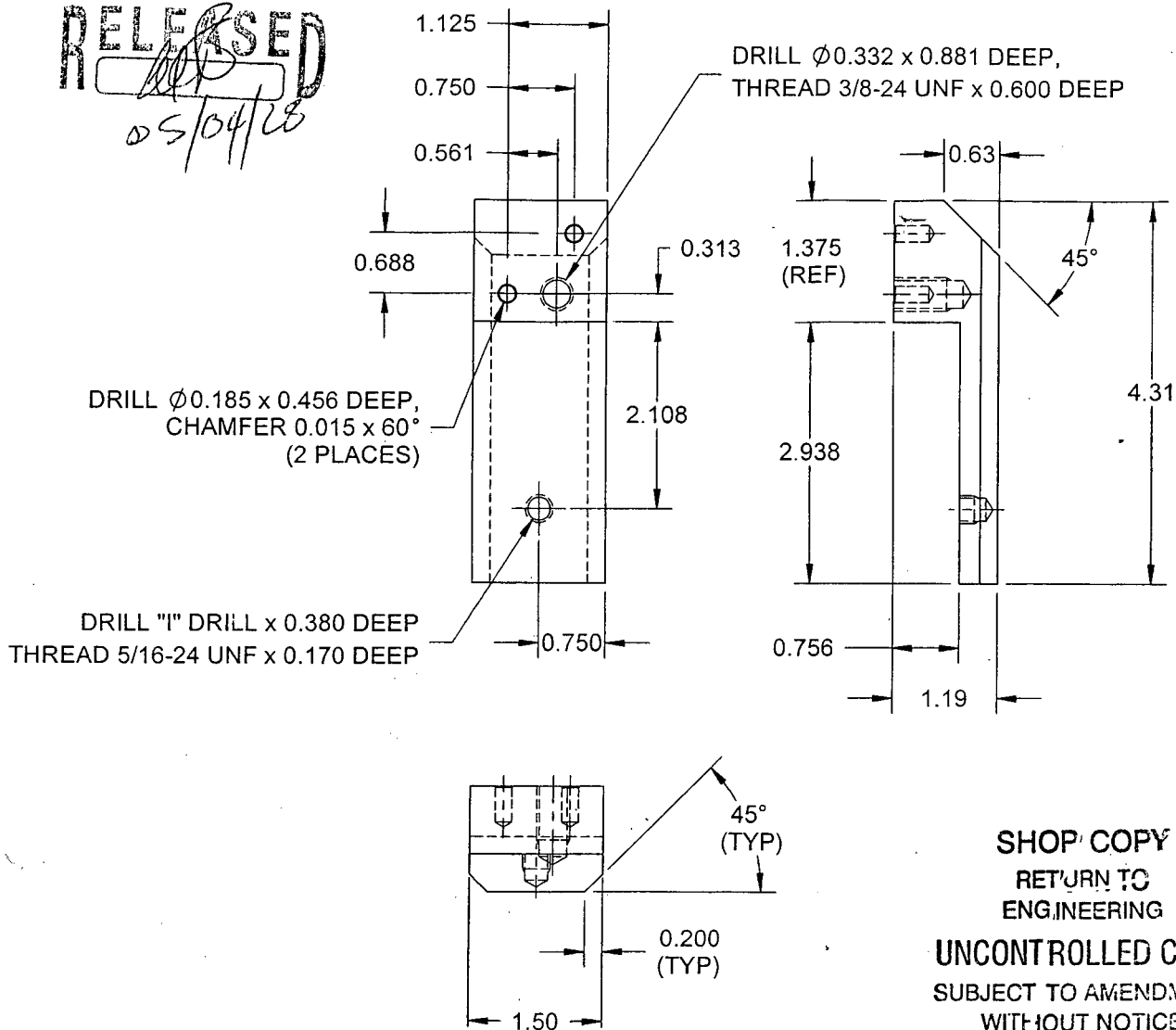
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3400	REV. A SHEET 6 OF 6
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2

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[Signature]
05/04/23



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WORK ORDER

NO. 22562

D3400-5 SLIDER BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

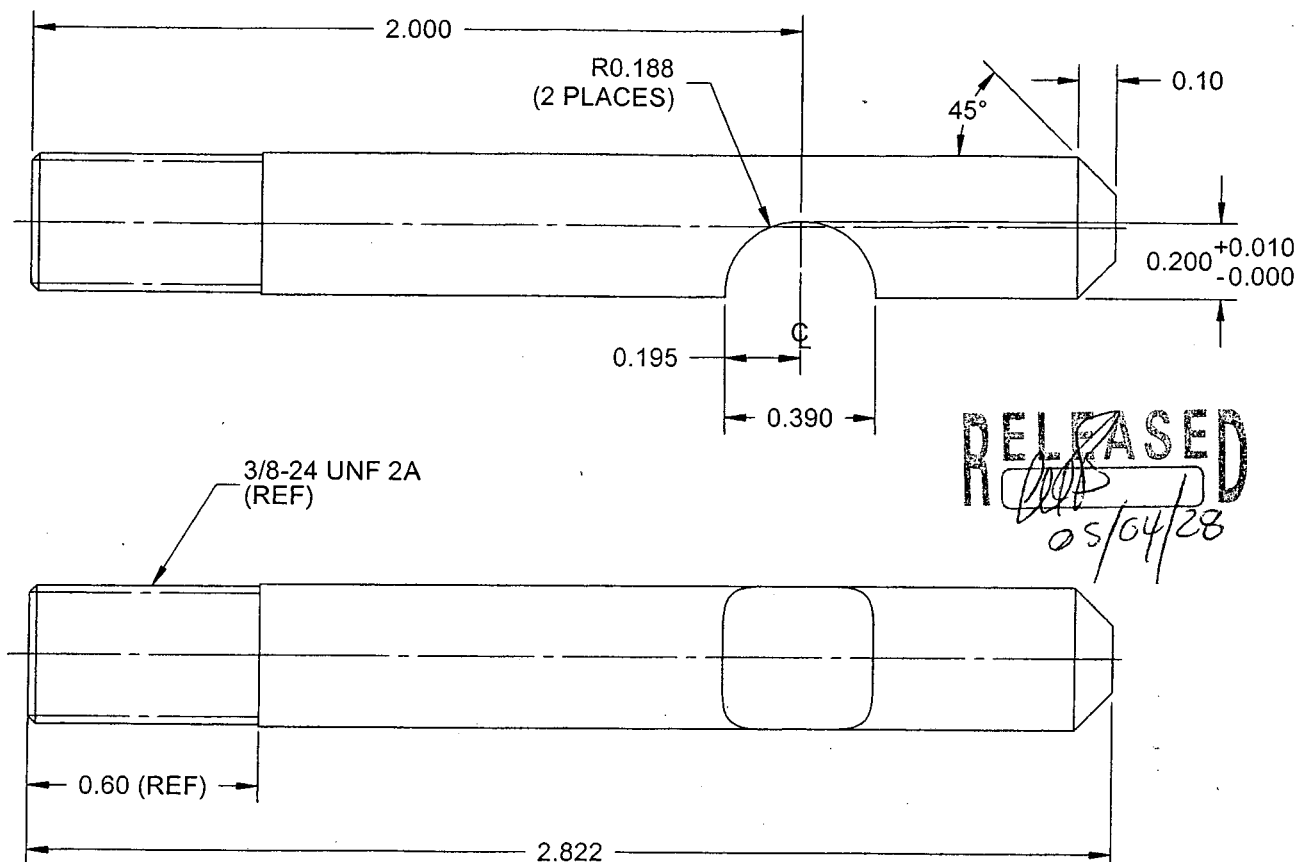
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3372	REV. B SHEET 8 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 2:1

SPECIFICATION CONTROL DRAWING



D3372-9 LOCK GUIDE

NOTES:

- 1) MATERIAL: AN6-36A BOLT, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. 22562

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Feb 24, 2005
03:25 pm

Work Order No : 0022562
Project Name : D3400-5
Project For : WK511
Work Order Type : Main
Main WO Number :
House Part Number : D3400-5
Description : Slider Body
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 02-24-05
Est Finish Date : 03-04-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART-AEROSPACE LTD		Work Order: 22562
Description:		Part Number: D3400-5
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.125	$\pm .010$	1.1255	/			
.750	$\pm .010$.747	/			
.561	$\pm .010$.561	/			
.688	$\pm .010$.689	/			
.313	$\pm .010$.315	/			
2.108	$\pm .010$	2.108	/			
.750	$\pm .010$.750	/			
.63	$\pm .030$.63	/			
45°		45°	/			
4.31	$\pm .030$	4.310	/			
1.19	$\pm .030$	1.190	/			
.756	$\pm .010$.757	/			
2.938	$\pm .010$	2.938	/			
1.375 Ref	$\pm .010$	1.376	/			
1.50	$\pm .030$	1.50	/			
.200	$\pm .010$.205	/			
45°		45°	/			
0.375						
0.185		0.185	/			

Measured by: SD	Audited by: BG	Prototype Approval:
Date: 05.09.25	Date: 05.09.25	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
10:16 am

Work Order No : 0022562
Project Name : D3400-5
Project For : WK511
Work Order Type : Main
Main WO Number :
House Part Number : D3400-5
Description : Slider Body
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 02-24-05
Est Finish Date : 03-04-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	7.50	100.00		
Production Cost	0.00	118.20	100.00	0.00	118.20
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	7.50	100.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	118.20	100.00		
Margin	0.000	0.000			
Selling Cost	0.00	118.20			

Labour Hrs/Amount Done : Estimated 0.00 Actual 0.00
Profits/(Loss) : 0.00 (-118.20)

MIS 0/15
u
11.13

Date: Monday, 14/11/2005 8:45:58 AM
 User: Alba Panzuto











Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SLIDER BODY
Job Number : 22562	
Estimate Number : 10478	
P.O. Number :	Part Number : D34005
This Issue : 14/11/2005 S.O. No. :	Drawing Number : D3400 REV A
Prsht Rev. : NC	Project Number :
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run :	Material :
Written By :	Due Date : 30/11/2005 Qty: 10 Um: Each
Checked & Approved By :	
Comment : EsT A 05.02.24 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B1500X01250	6061-T6 Bar 1.5" x 1.25"
2.0	BAND SAW	BAND SAW
		
Comment: BAND SAW Cut blank: 1.500" x 1.250" x 4.435" long Machine D3400-5 as per Folio FA515 and Dwg D3400 Identify as D3400-5 Deburr		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
		
Comment: SECOND CHECK		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		
6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SLIDER BODY

Job Number: 22562

Part Number: D34005

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

AN636A

BOLT

8.0

BAND SAW

BAND SAW



Comment: BAND SAW

Fabricate D3372-9 using AN6-36A bolt as per Dwg D3372.

Cut to length, then mill slot when bolt and D3400-5 are assembled as per Dwg D3400.

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

Mask all holes and pins

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

